

Date: Tuesday, 11/22/2005 4:58:47 PM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BUSHING
Job Number	: 24942		
Estimate Number	: 10310		
P.O. Number	: N/A	Part Number	: D26175
This Issue	: 11/22/2005 S.O. No. : N/A	Drawing Number	: D2617 REV D2
Prsh Rev.	: NC	Project Number	: N/A
First Issue	: 11/22/2005 Type : MACHINED PARTS	Drawing Revision	: D2
Previous Run	: 24401	Material	: N/A
Written By	: See Comment below	Due Date	: 12/2/2005 Qty: 60 Um: Each
Checked & Approved By	: See Comment below		
Comment	: Est H 04.07.14 Rerformat; added step 5 KJ/JLM		

Additional Product

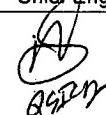
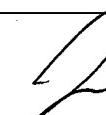
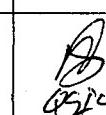
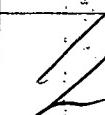
Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6T0500W058	6061-T6 Tube .500 x.058W	
		Comment: Qty.: 0.0205 f(s)/Unit Total : 1.2285 f(s) 6061-T6 Round Bar 1.5" Material: 6061-T6 (QQ-A-225/8 or QQ-A-200/8 or WW-T-700/6) Ø0.500" tubing x 0.058" wall M6061T6T0.500W.058)	
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	
		Comment: HARDINGE CNC LATHE SMALL Machine as per Folio FA438 and Dwg D2617 Ø0.500" tubing x 0.058" wall	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK J.L	
		Comment: SECOND CHECK	
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: Deburr break all unmarked sharp edges 0.005 to 0.010	

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 05/12/02
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
05-11-30	5	I part deburred to much on the side	 ASZER	Scrap & destroy	 05/11/30	 05-11-30	 05-12-02	 05-11-30

NOTE: Date & initial all entries

Date: Tuesday, May 22/2005 4:58:47 PM
User: Linda

Process Sheet

Customer: CUDDA 001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 24942

Part Number: D26175

Job Number:



Seq. #: Machine Or Operation:

Description :

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT ALODINE

10/05/12/01 59

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

DC 05/11/30 59

8.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

10/05/12/01 59

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 49

10/05/12/01 59

10.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

5/05/05/12/05 59

DC 05/12/02

Job Completion



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

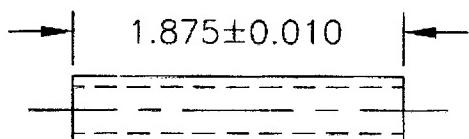
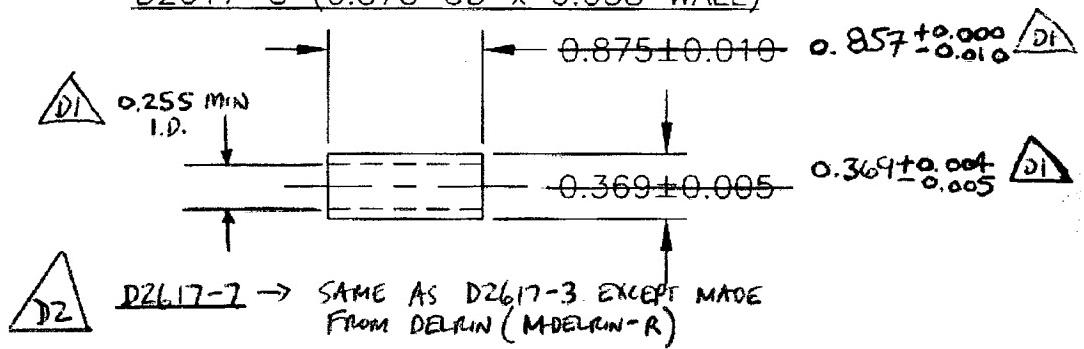
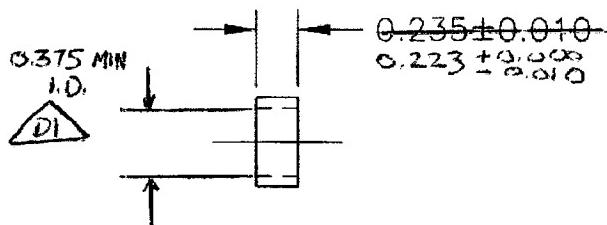
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

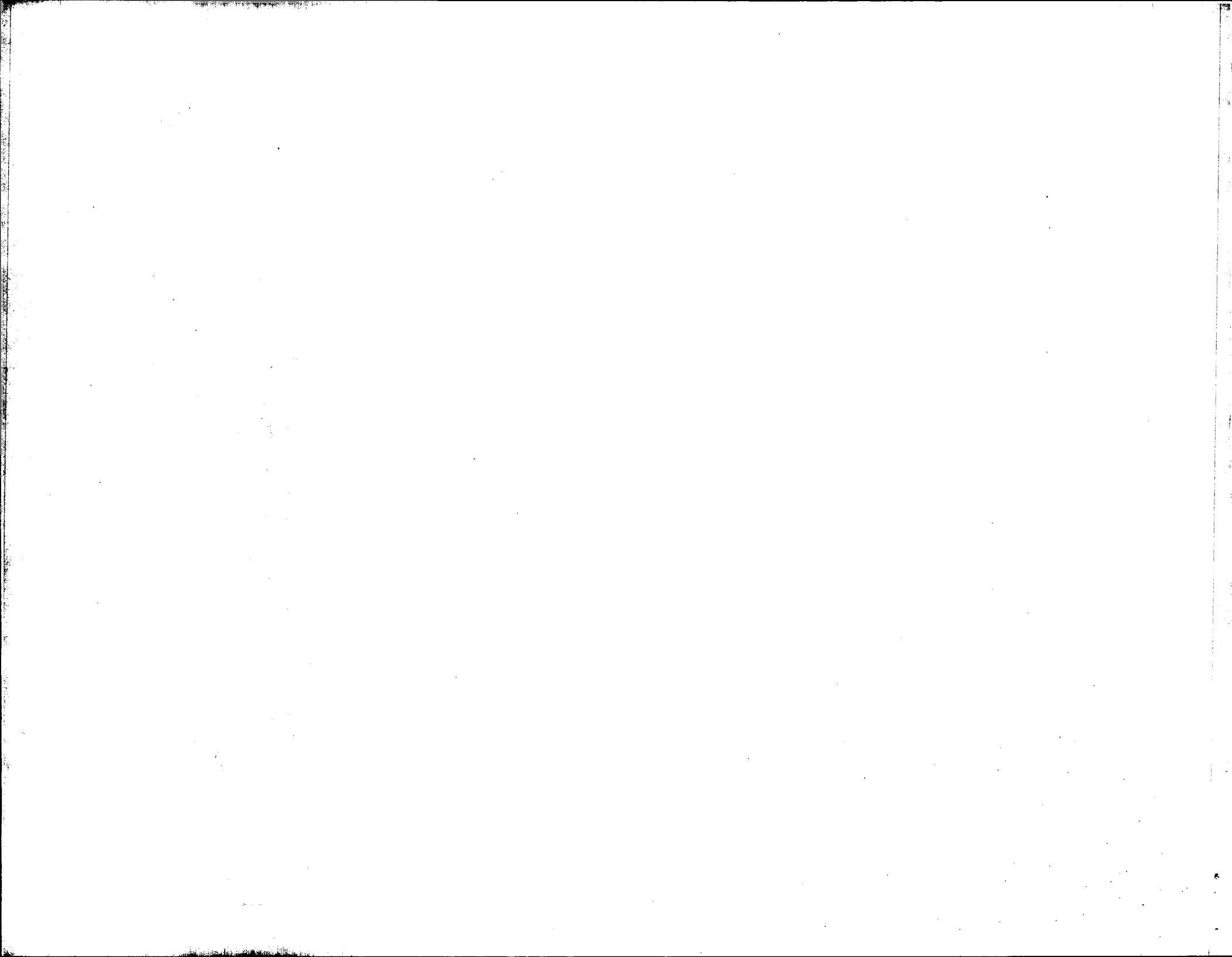
DESIGN BW	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D2617	REV. D SHEET 1 OF 1
DATE 01.07.04		TITLE BUSHING	SCALE 1:1
D2 04.09.10 H1P ADD D2617-7	A	96.10.08	NEW ISSUE
	B	97.05.08	.875 WAS 1.125
	C	97.06.04	0.369 DIA WAS 0.375
	D	01.07.04	ADD MAT'L SPEC AND TOL./DIM. NOTE
	DI	<i>CP</i> 04.07.12	CORRECT TOLERANCE (NCR 774)

D2617-1 (0.375 OD x 0.058 WALL)D2617-3 (0.375 OD x 0.058 WALL)D2617-5 (0.500 OD x 0.058 WALL)**RELEASED**
01.07.05 *#*NOTES:

- 1) MATERIAL: 5052-H32 (QQ-A-225/7 OR WW-T-700/4)
OR 6061-T6 (QQ-A-225/8, QQ-A-200/8, OR WW-T-700/6)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH, ALODINE PER QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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DART AEROSPACE LTD	Work Order:	24942
Description: Bushing	Part Number:	D2617-5
Inspection Dwg: D2617	Rev: D1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>Tin</u>	Audited by:	<u>J.L.</u>	Prototype Approval:	N/A
Date:	05/16/27	Date:	05.11.27	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.09	New Issue	KJ/JLM	

